

ID 123195

\*123195\*

Page 1

49:58 PM

D5127-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Item ID:

Item Name: Shim, Small

Start Date: 31/07/2014 Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 06/08/2014 Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D5127

REV A

100

0.00

\*100\*

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank:1.510" LONG

DAS

02

9-89

14-08-02 (X13)

110

0.00

\*110\*

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FB333 and Dwg

FOLIO REV: AA

DWG REV: A

- Deburr

DAS

02

9-89

14-08-02 (X13)

# Work Order ID 123195

July-31-14 12:49:58 PM

**\*123195\***

Page 2

Item ID: D5127-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Shim, Small  
 Start Date: 31/07/2014 Start Qty: 12.00 **\*12\*** Cust Item ID:  
 Required Date: 06/08/2014 Req'd Qty: 12.00 **\*12\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*140*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

DAS  
02 14-08-02  
9-89

on 14/08/03

13 148-5

**\*123195\***

July-31-14 12:49:58 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*12\***

**\*12\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

141

0.00

**\*141\***

QC

## Memo

0.00

## Quality Control

150

0.00

**\*150\***

**Powdercoat**

## Memo

0.00

## Powder Coating

START TIME: 9:00

OVEN TEMPERATURE: 320 FINISH TIME:

9:30

160

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

July-31-14 12:49:58 PM

**\*123195\***

Page 4

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Shim, Small

**Start Date:** 31/07/2014    **Start Qty:** 12.00

**\*12\***

**Cust Item ID:**

**Required Date:** 06/08/2014    **Req'd Qty:** 12.00

**\*12\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

**Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

170

Identify as per dwg & Stock Location: ST136 0.00

0.00

**\*170\***

### Packaging

## Memo

0.00

### Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

MLJ 1408-15

MLJ 14-08-14

# Picklist Print

July-31-14 12:49:57 PM

Page 1

Work Order ID: 123195

\*123195\*

Parent Item: D5127-3

\*D5127-3\*

Parent Item Name: Shim, Small

Start Date: 31/07/2014

Required Date: 06/08/2014

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 14-07-31 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.250X01.00

Purchased

No

f

30.5000

2

0

\*M6061T6B0 250X01 000\*

\*\*

DAS

02

9-89

BT 14.08.02

6061-T6 Bar .250 x 1.00

Location

Loc Qty

Loc Code

MAT049

30.5

102039

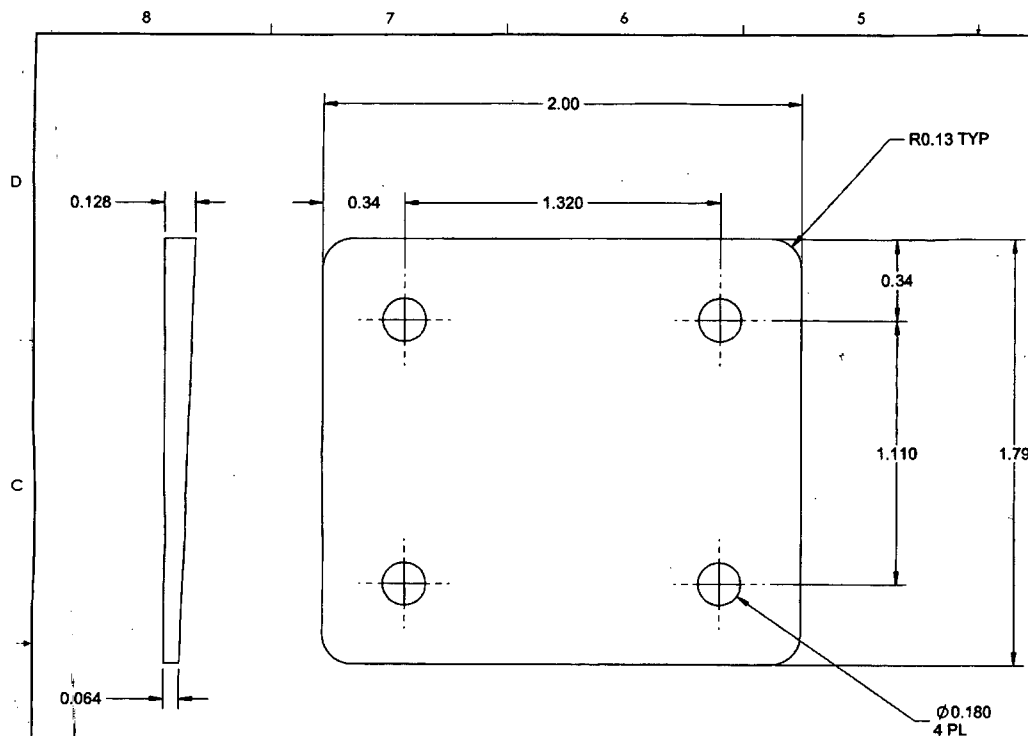
12

18237

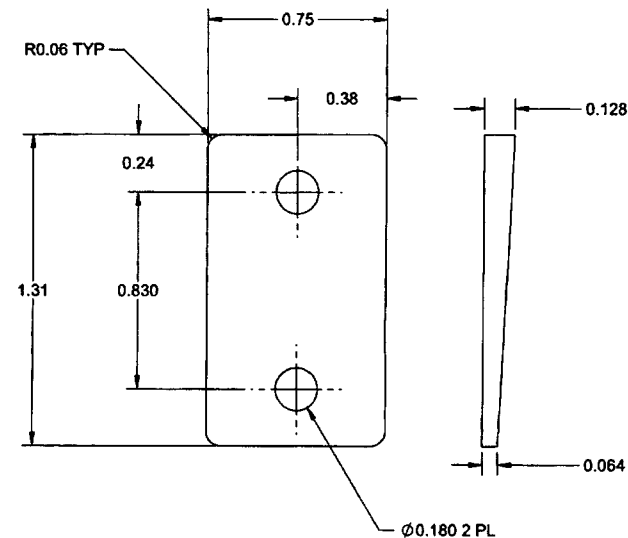
6.5

19059

12



**D5127-1 SHIM LARGE**



**D5127-3 SHIM SMALL**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5127-1" OR "D5127-3" PER QSI 044 6.7
- 7) WEIGHT: D5127-1: 0.03 lbs, D5127-3: 0.01 lbs

**RELEASED**  
2014-07-28

A NEW ISSUE		DB	14.07.09
REV.	DESCRIPTION		BY DATE
DESIGN	DB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	ML	DRAWING NO.	REV. A
MFG. APPR.	JLM	<b>D5127</b>	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	<b>SHIM</b>	NTS
DATE	<b>14.07.09</b>		COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

APPROVED

